

Date: Wednesday, 18/02/2009 10:58:39 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARING ASSEMBLY	
Job Number	: 45867		Part Number	: D3121241	
Estimate Number	: 10716		Drawing Number	: D3121 REV E	
P.O. Number	:		Project Number	: N/A	
This Issue	: 18/02/2009 S.O. No. :		Drawing Revision	: E	
Prsht Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 25/02/2009	
Previous Run	: 44493		Qty:	25	
Written By	:		Um:	Each	
Checked & Approved By	: <u>JULIA DAWSON</u>			96	
Comment	: Est Rev:A 04.02.18 New issue KJ/DS Est Rev:B ECN 1060 07-11-12 DD verified by:EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MDELRINR12500	DELRIN ROUND BAR 1.25"
		Comment: Qty.: 0.0546 f(s)/Unit Total : 1.3650 f(s) Material: Ø1.25 Delrin Rod (M-DELRIN-R1.2500)Identify as D3121-25 Batch: _____
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		Comment: HARDINGE CNC LATHE SMALL
		1-Turn D3121-25 Cap as per Folio FA387
		2-Deburr
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		D3121-25 B 38981 (1x)
		Comment: SECOND CHECK <u>full from stock</u> B 38233 (1x) B 38580 (34x)
5.0	D312123	Bearing
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 25.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3121-23 Bearing B 43550

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 10:58:39 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 45867

Part Number: D3121241

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: QA

Feb/2/18 (46)

SB 09/02/18 (46)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



WF
09-0216

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						✓	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

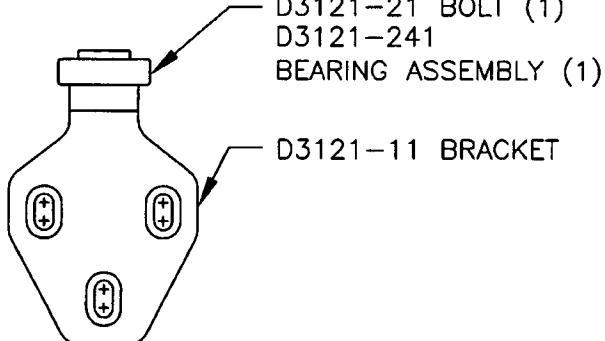
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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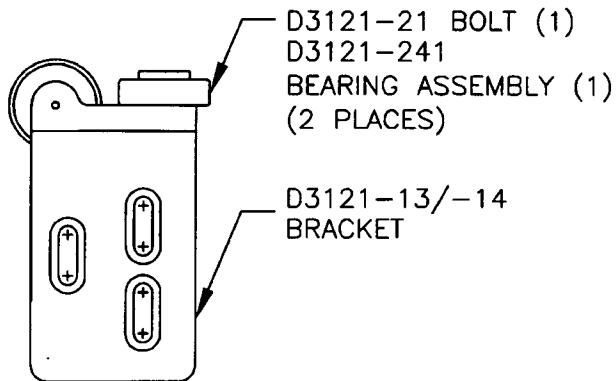
NOTE: Date & initial all entries

DART

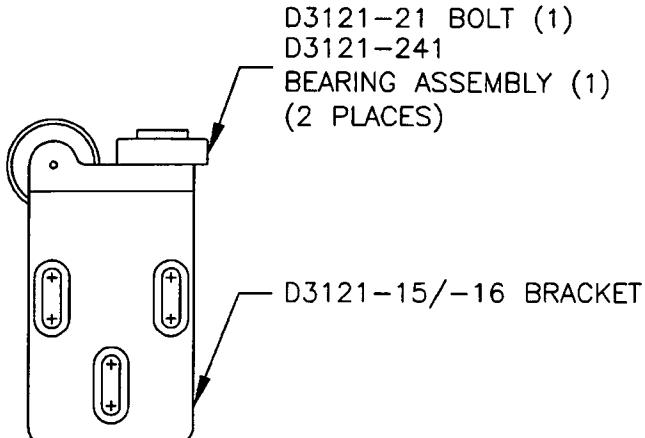
DESIGN <i>4</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>4</i>	APPROVED <i>4</i>	DRAWING NO. D3121 REV. E SHEET 1 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07 *WD***D3121-041 BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-33)

**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-37/-38)

**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-35/-36)

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NO. *W5867*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

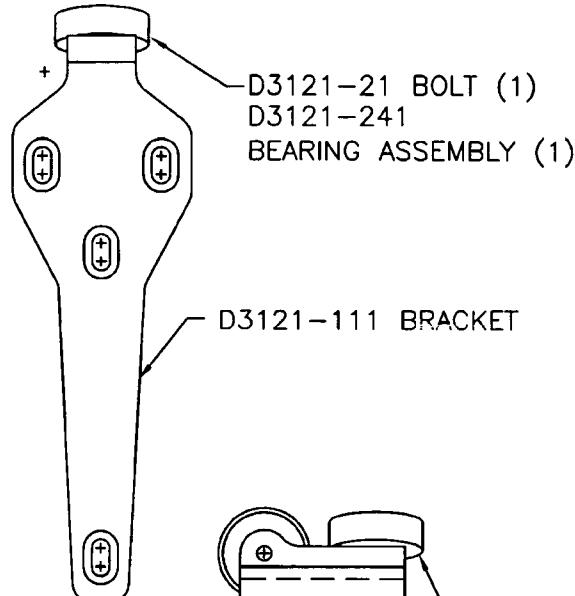
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

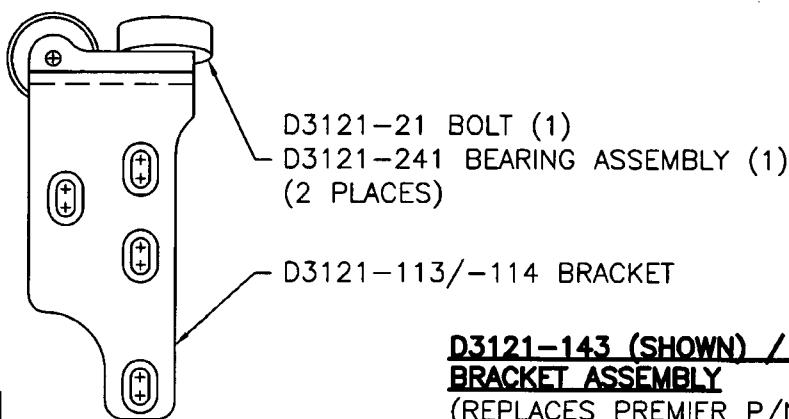
DART

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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3121	REV. E SHEET 2 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

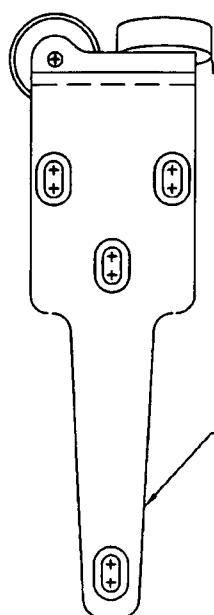


D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

RELEASED
07.11.07



D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

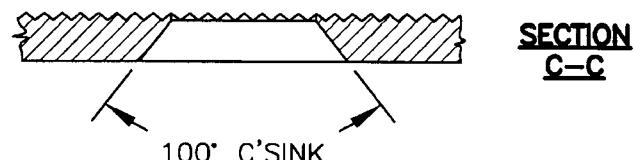
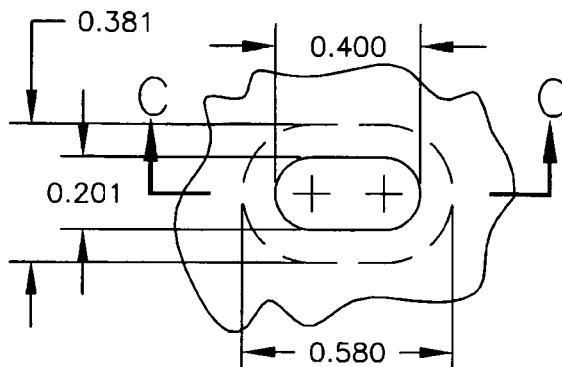
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

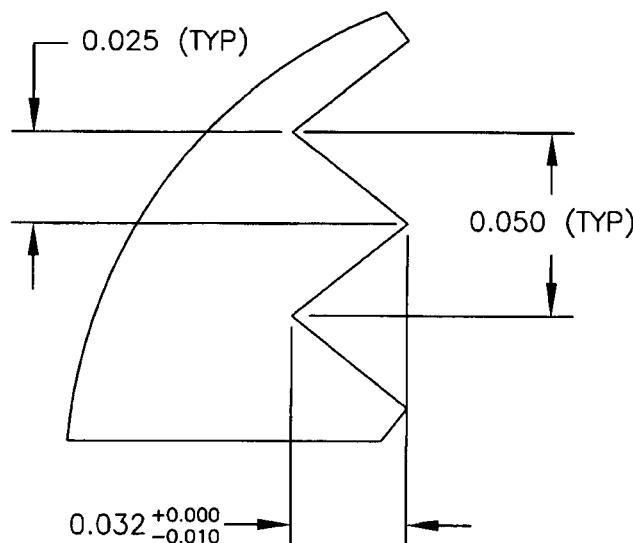
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CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3121	REV. E SHEET 3 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



RELEASED
07.11.07 *MP*

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

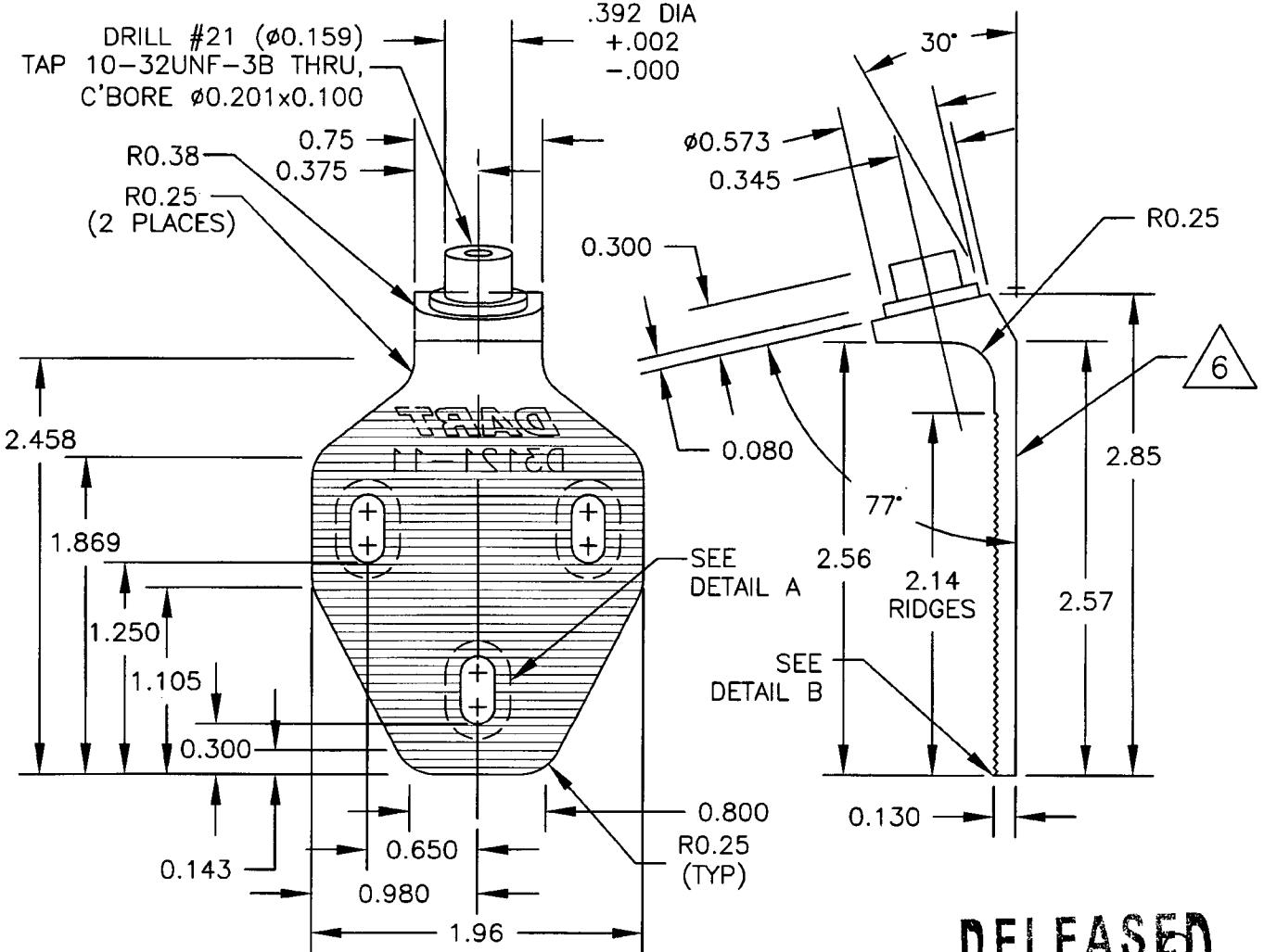
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3121	REV. E SHEET 4 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1



RELEASED
07.11.07 M

D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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) WORK ORDER
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

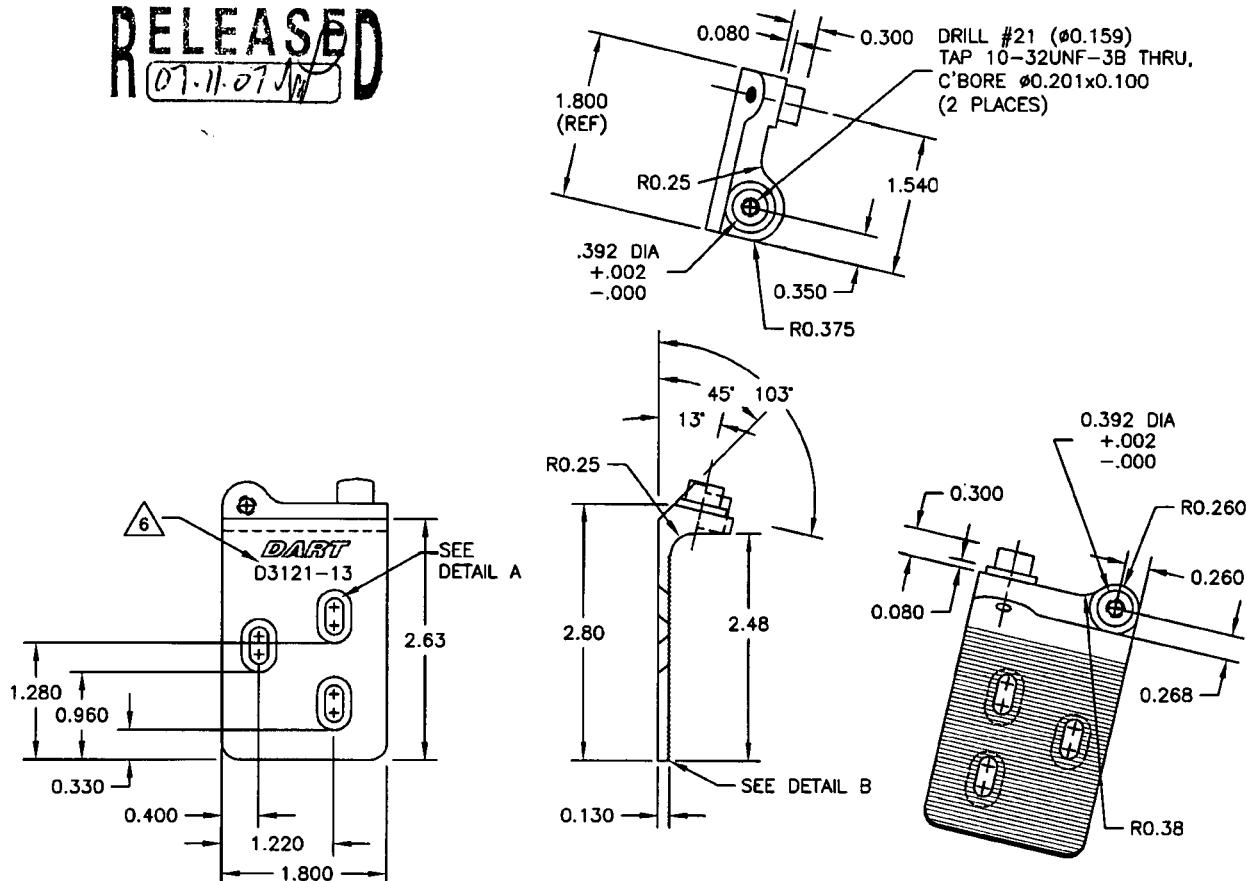
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3121
DATE		REV. E SHEET 5 OF 10 1:2

RELEASED
07.11.07**D3121-13 BRACKET (SHOWN)****D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

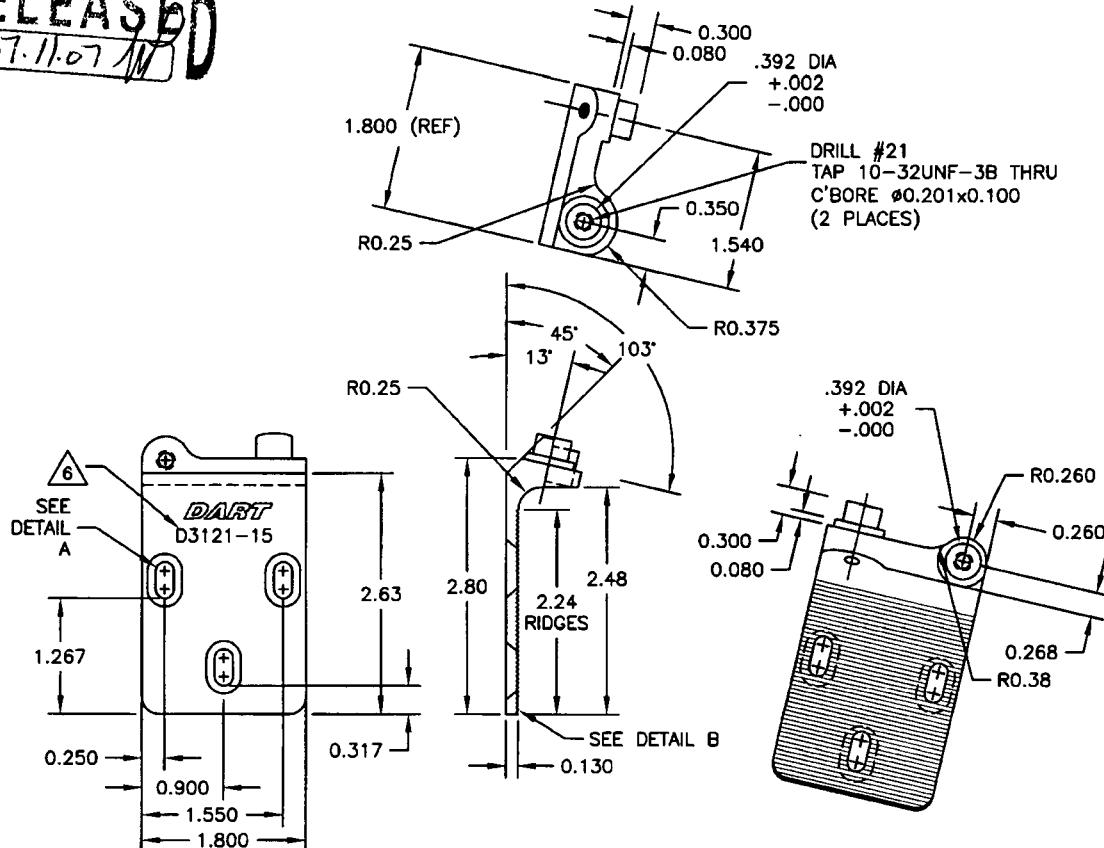
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3121 REV. E
DATE		SHEET 6 OF 10 1:2

RELEASED
07.11.07**D3121-15 BRACKET (SHOWN)****D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) SHOP COPY
RETURN TO
ENGINEERING
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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NO. 105201

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

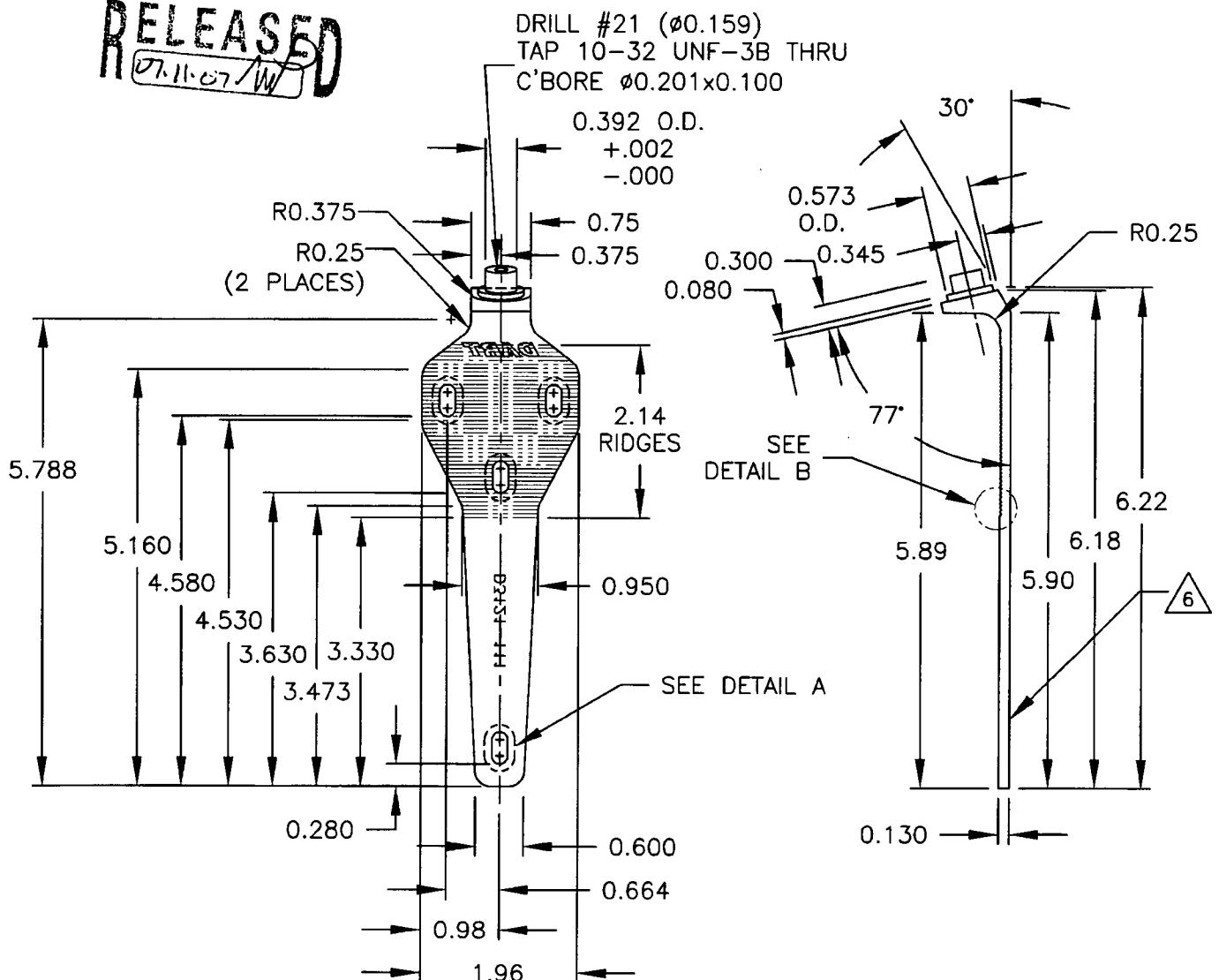
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07 / W



D3121-111 BRACKET

1) REPLACES PREMIER P/N B32-23001-11
2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

RETURN TO
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WORK ORDER
NO 45867

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WORK ORDER
NO 45867

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

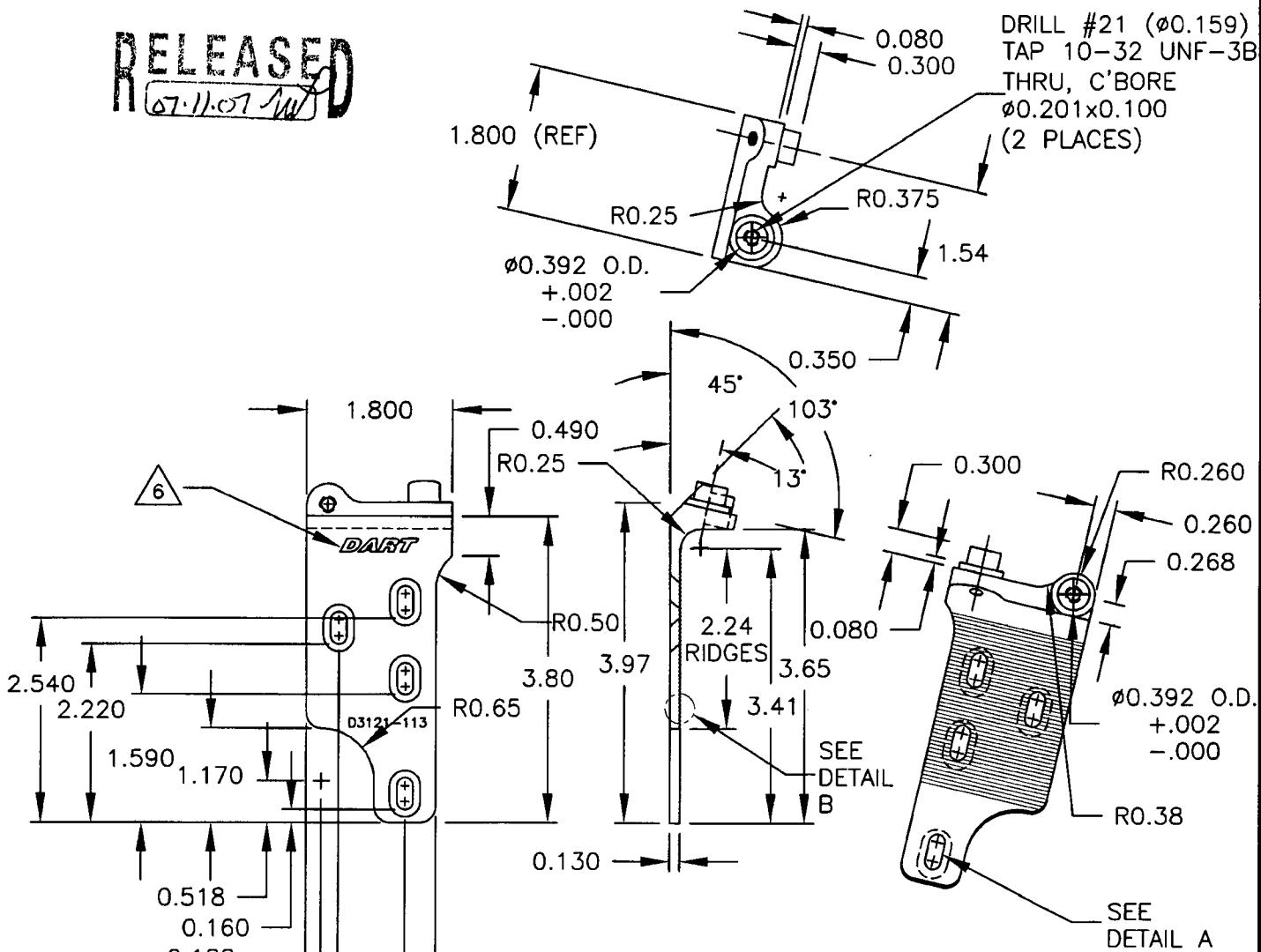
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PART

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CHECKED 	APPROVED RE 	DRAWING NO. D3121	REV. E SHEET 8 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED
07.11.07 *[Signature]*



**D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

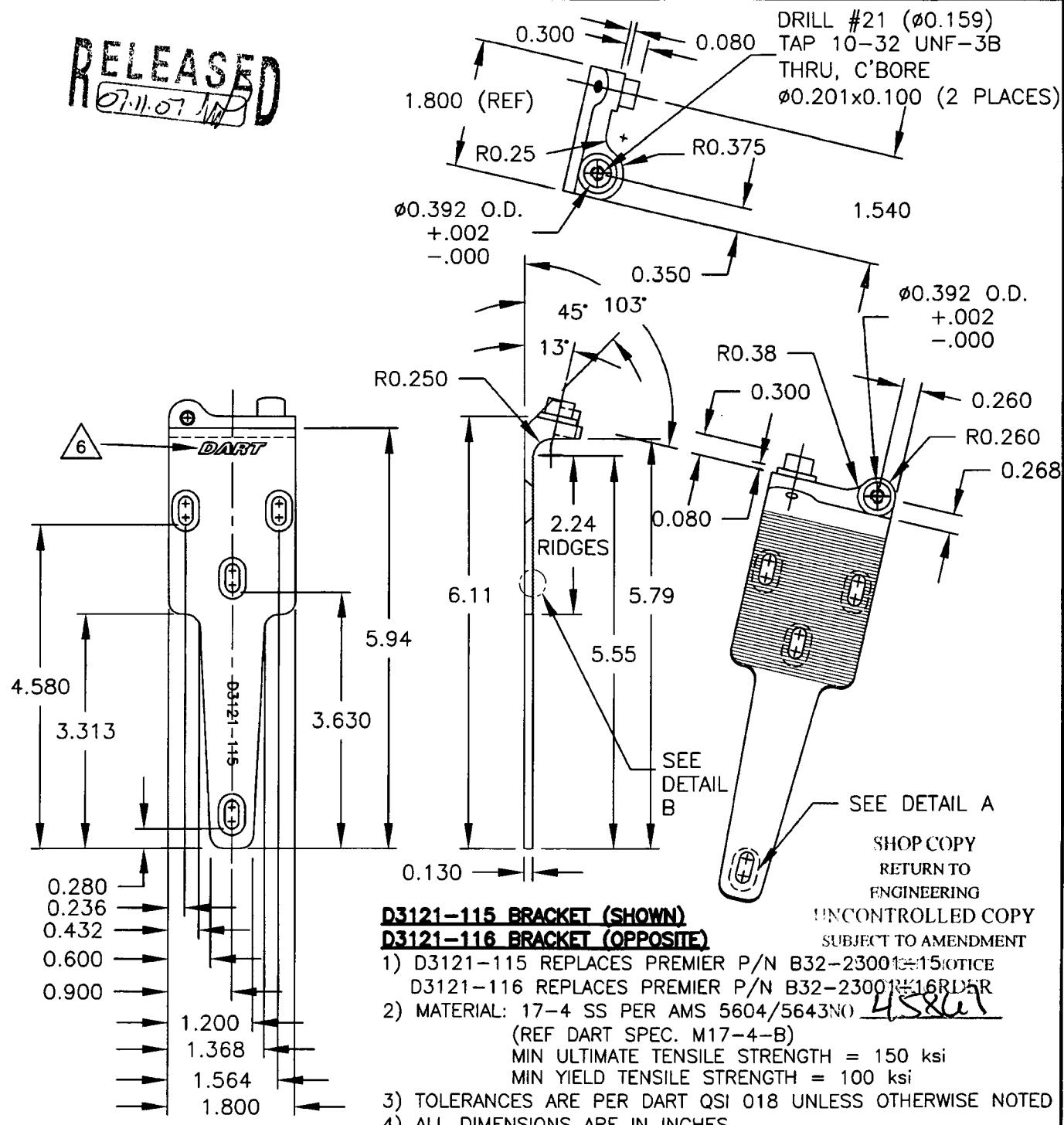
DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D3121	SHEET 9 OF 10

DATE
07.11.07

TITLE
BRACKET ASSEMBLY

SCALE
1:2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

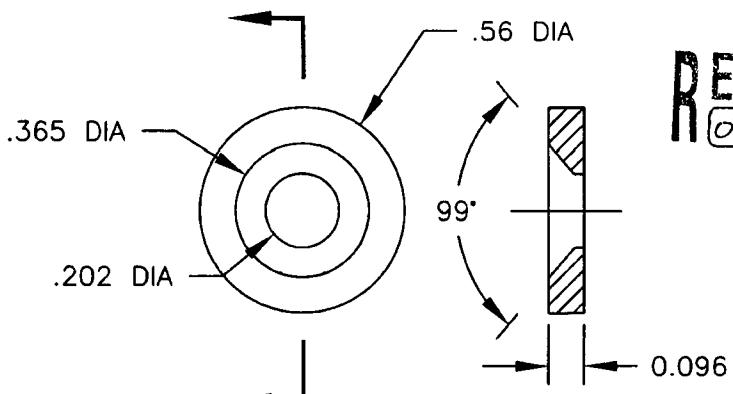
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

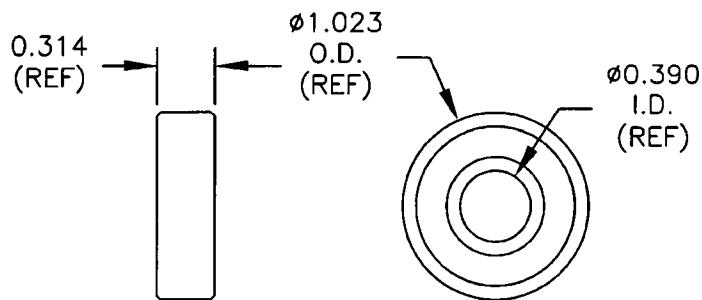
DART

DESIGN <i>CH</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



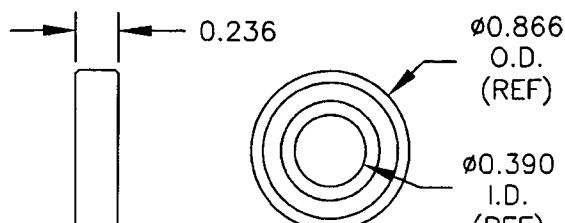
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



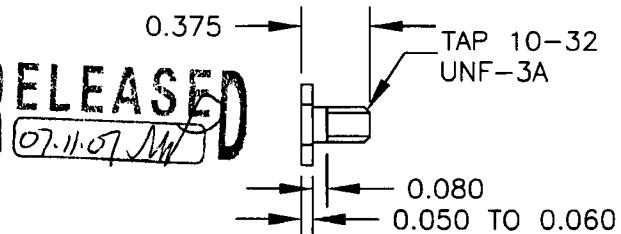
D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



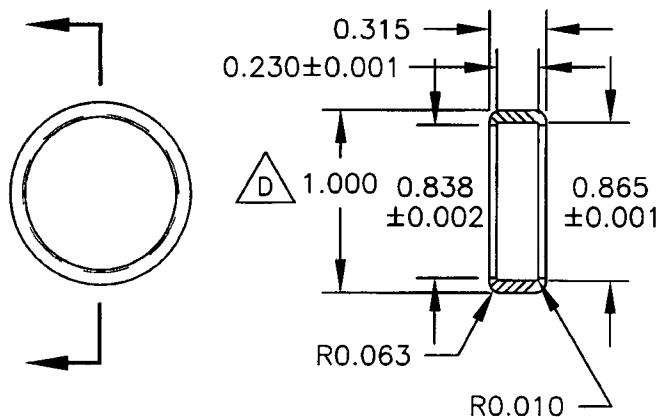
D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES



D3121-21 BOLT (SCALE 1:1)

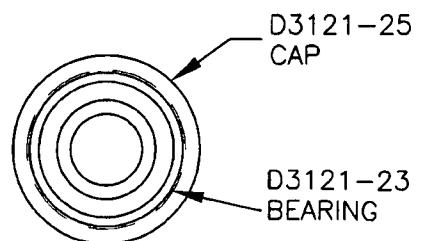
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *455601*



D3121-241 BEARING ASSEMBLY (SCALE 1:1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries